

Date: Monday, 20/04/2009 2:40:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 47322
 Estimate Number : 12866
 P.O. Number :
 This Issue : 20/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 47139
 Drawing Name : DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS KIT
 Part Number : D412702043B
 Drawing Number : IIN D412-702 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 01/05/2009 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JUD 09.04.20
 Comment :
 est rev A 07.05.10 new issue EC
 est rev C 07.06.20 changed AN44 4A to AN444A EC
 Est Rev:D 07-07-06 As per Rev E JLM
 Est Rev:E 08-03-31 now at chg003 ECN1150 DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Handwritten: JUD 09/04/28



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-702-043B CHG003

Handwritten: S 02/05/07

2.0 D412702059 Grommet



Handwritten: Jala



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

GROMMET KIT

batch:

Handwritten: 45410 x1 47538 x1

Handwritten: JUD 09/04/28

3.0 D412702101B Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

HARNESS ASSEMBLY

batch:

Handwritten: 47134 x1 B47443 x1

Handwritten: JUD 09/04/28

4.0 D412702103B Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

HARNESS ASSEMBLY

batch:

Handwritten: 47135 x1 B47444 x1

Handwritten: JUD 09/04/28

5.0 D412702105B Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

HARNESS ASSEMBLY

batch:

Handwritten: 47136 x1 B47445 x1

Handwritten: JUD 09/04/28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 47322

Part Number: D412702043B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D412702107B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B47446

7.0

D412702109B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

HARNESS ASSEMBLY

batch: 47447

8.0

D35421

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

BRACKET

batch: B44816

9.0

D35711

Guide



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

GUIDE

batch: 46282

10.0

D35713

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

GUIDE

batch: B31861 x1

B47142 x1
B46531 x3

B45926 x3

11.0

D3578041

Doubler



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

DOUBLER

batch: B46653 x2

B47143 x10

12.0

D3610041

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

BRACKET

batch: B46283

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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KIT

Job Number: 47322

Part Number: D412702043B

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
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| | | |
|------|--------|-----|
| 13.0 | D36181 | CAP |
|------|--------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

CAP

batch: B32426

| | | |
|------|--------|------|
| 14.0 | AN410A | Bolt |
|------|--------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: 108986

| | | |
|------|--------|------|
| 15.0 | AN444A | Bolt |
|------|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

bolt

batch: 104806

| | | |
|------|-------------|-------|
| 16.0 | MS24693S274 | Screw |
|------|-------------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M108560

| | | |
|------|------------|-------|
| 17.0 | MS24694S56 | SCREW |
|------|------------|-------|



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

SCREW

batch: M104407

| | | |
|------|------------|-------|
| 18.0 | MS24694S58 | Screw |
|------|------------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M104407

| | | |
|------|------------|-------|
| 19.0 | MS24694S60 | Screw |
|------|------------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M104407

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 47322

Part Number: D412702043B

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
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|------|------------|--------|
| 20.0 | AN960JD416 | Washer |
|------|------------|--------|



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)
Washer
batch: M110363

SS 09/04/28 (X2)

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|------|-------------|--------|
| 21.0 | AN960JD416L | Washer |
|------|-------------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)
Washer
batch: M110153

SS 09/04/28 (X2)

| | | |
|------|-----------|-----|
| 22.0 | MS21042L4 | Nut |
|------|-----------|-----|



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)
Nut
batch: M110450

SS 09/04/28 (X2)

| | | |
|------|----------|--------------|
| 23.0 | CR321244 | Cherry Rivet |
|------|----------|--------------|



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)
Cherry Rivet
batch: M111127

SS 09/04/28 (X2)

| | | |
|------|-----|------------------------------------|
| 24.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
|------|-----|------------------------------------|



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/05/07 (X2)

| | | |
|------|-------------|-----------------------|
| 25.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-043B

Location:

PPP Rev: ST274 Rev C

SS 09/05/07 (X2)

| | | |
|------|------|------------------------------|
| 26.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|------|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

09/05/07

Job Completion



MF
09-05-07

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

4.0 INSTALLATION PROCEDURE FOR 3-POINT SHOULDER HARNESS KITS

This section provides installation instructions for the D412-702-041A/-043A/-045A/-047A/-049A and the D412-702-041B/-043B/-045B/-047B/-049B kits. The only difference between the D412-702-041A/-043A/-045A/-047A/-049A kits and the D412-702-041B/-043B/-045B/-047B/-049B kits is in the attachment of the shoulder belts to the lap belts, as shown in **Figures 4.1** and **4.2**.

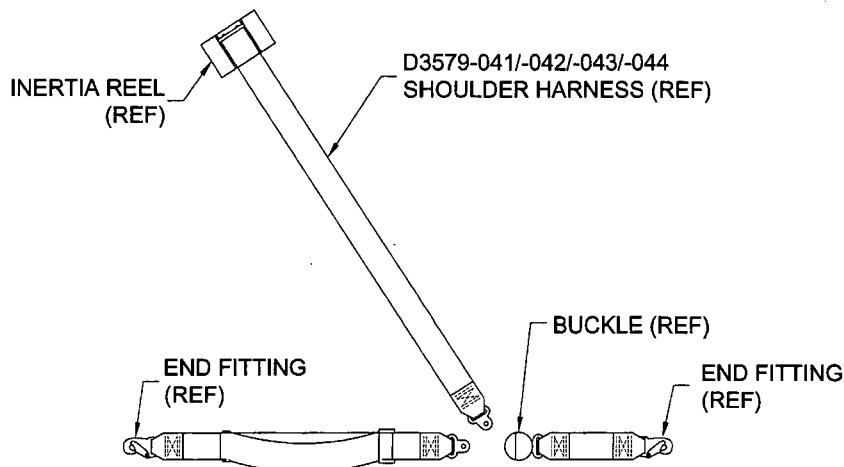


FIGURE 4.1. D412-702-041A/-043A/-045A/-047A/-049A SHOULDER HARNESSES

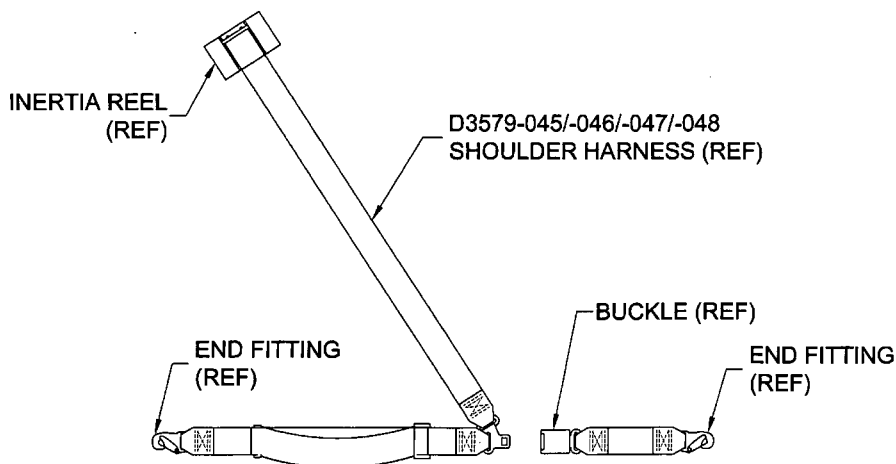


FIGURE 4.2. D412-702-041B/-043B/-045B/-047B/-049B SHOULDER HARNESSES

4.1 Installation of the Dart 3-Point 13-Man Shoulder Harness Kits (D412-702-041A/-041B)

The Dart D412-702-041A kit provides shoulder harnesses for all 13 passenger seating positions and contains all the components of the D412-702-043A, D412-702-045A and D412-702-047A kits. The Dart D412-702-041B kit provides shoulder harnesses for all 13 passenger seating positions and contains all the components of the D412-702-043B, D412-702-045B and D412-702-047B kits. Install per Sections 4.2, 4.3 and 4.5 of this IIN.

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WORK ORDER

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Revision: **E**
Date: 07.06.27